GREEN **Dart Aerospace Ltd.**

Date: Tuesday, 07/04/2009 3:23:01 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SHORT T-HANDLE ASSY
Job Number	: 47061		
Estimate Number	: 13529		
P.O. Number	:	**Part Number**	: PB674300163
This Issue	: 07/04/2009 **S.O. No.** :	**Drawing Number**	: B6743001 P.15
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: 07/04/2009 **Type** : LARGE FAB ASSY	**Drawing Revision**	: B1
Previous Run	: 45023	**Material**	:
Written By	:	**Due Date**	: 14/04/2009 **Qty:** 1 **Um:** Each
Checked & Approved By	: MF 09-04-08		
Comment	: Est Rev:A 08-07-29 new issue DD verified by:ec		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PB6743001131	Tube End Cap

✓

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Tube End Cap batch: B45770 =2X SP 09.04.09.

2.0	PB6743001129	Tube Handle

✓

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Tube Handle batch: B45002 =1X SP 09.04.09.

3.0	PB6743001127	Handle Arm

✓

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle Arm batch: B43307 =1X SP 09.04.09.

4.0	PB6743001157	Tube

✓

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Tube batch: B43390 =1X SP 09.04.09.

5.0	CR321342	Cherry Rivet

✓

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cherry Rivet batch: ~~LL10806~~ ~~1X~~ SP 09.04.09
102569 =1X

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
1- chamfer both ends (0.090") on -129 and -127
2- chamfer (0.090") only the angle end on -157
3- drill #40 hole in center of -129 before welding -131 caps, to let air out
4- weld -131 to -129 as per dwg
5- grind weld flush
6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
7- grind weld flush
8-i nstall rivet as per dwg

09.04.14 (18)

7.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION

PD 09-04-14 (1)

8.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

09/04/14 (4)

9.0	POWDER COATING	POWDER COATING

M18144

Comment: POWDER COATING

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat****
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: 2:20pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 2:50pm

09-04-16 (11)

10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DR 09-04-16 (1)

11.0	240107	SPRING SLOTTED PIN

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SPRING SLOTTED PIN
batch: M111088

09.04.20

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	PB6743001133	Clevis

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Clevis
batch: B45001 09.04.20

13.0	PB6743001137	Locking Sleeve

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Locking Sleeve
batch: B44999 09.04.20

14.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble by drilling thru both -157 and -133 as per dwg
2- install spring slotted pin as per dwg

09.04.20 X1

15.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 09/04/20 (4)

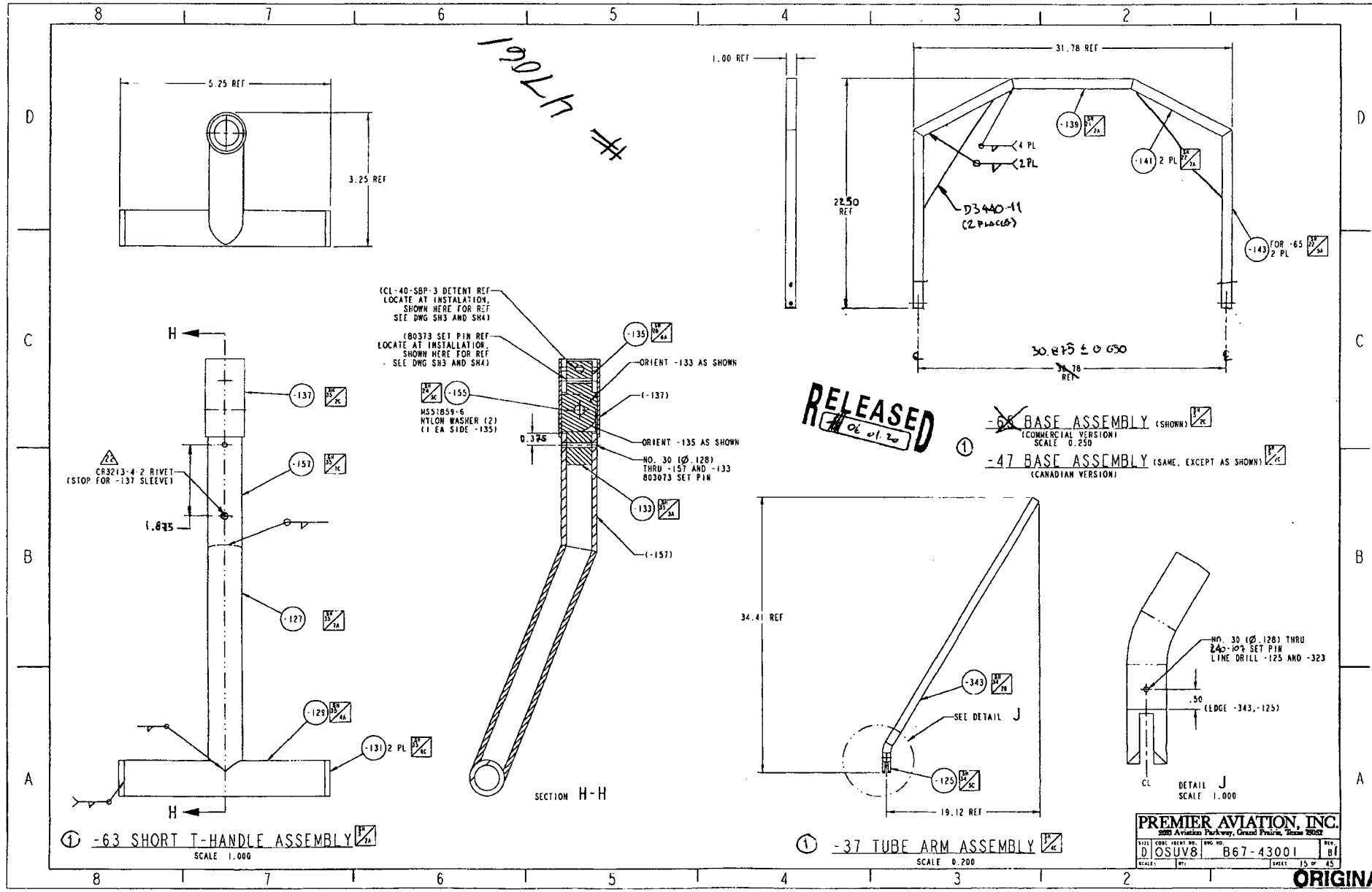
16.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____ 9/4/20 Sip (2)

17.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 09/04/22

Job Completion MF 09-04-21



RELEASED
OK VL 2-20

1 -63 SHORT T-HANDLE ASSEMBLY
SCALE 1.000

1 -~~08~~ BASE ASSEMBLY (SHOWN)
(COMMERCIAL VERSION)
SCALE 0.250

-47 BASE ASSEMBLY (SAME, EXCEPT AS SHOWN)
(CANADIAN VERSION)

1 -37 TUBE ARM ASSEMBLY
SCALE 0.200

PREMIER AVIATION, INC.
2001 Aviation Parkway, Grand Prairie, Texas 75052

SIZE	CONT. IDENT NO.	DWG NO.	REV.
D	OSUV8	B67-43001	B1
SCALE:	WT:	SHEET 15 OF 45	

ORIGINAL